

Date: Wednesday, 21/05/2008 11:30:13 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : ANGLE-PROTO
Job Number : 05002	
Estimate Number : 10804	
P.O. Number :	
This Issue : 21/05/2008 S.O. No. :	Part Number : D37091 <i>PROTOTYPE 08.05.20</i>
Prsht Rev. : NC	Drawing Number : D3709
First Issue : / /	Project Number :
Previous Run : 05000	Drawing Revision :
Written By : <i>W</i>	Material :
Checked & Approved By : <i>W</i>	Due Date : 28/05/2008
Comment :	Qty: 1 Um: Each

Additional Product

# PROTOTYPE PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 MAKE PER DRWG D3709 REV.A

*08.05.21*

2.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.5000 sf(s)/Unit Total : 0.5000 sf(s)  
~~angle 750 x 750 x 1/16w~~

*M107387*

*08.05.21*

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING  
APPROVAL**

*08.05.21*

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 ACID ETCH AND ALODINE

*Not required*

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Not required*

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 ENGINEERING -MARC

*08.05.21*

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## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: ANGLE-PROTO

Job Number: 05002

Part Number: D37091

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



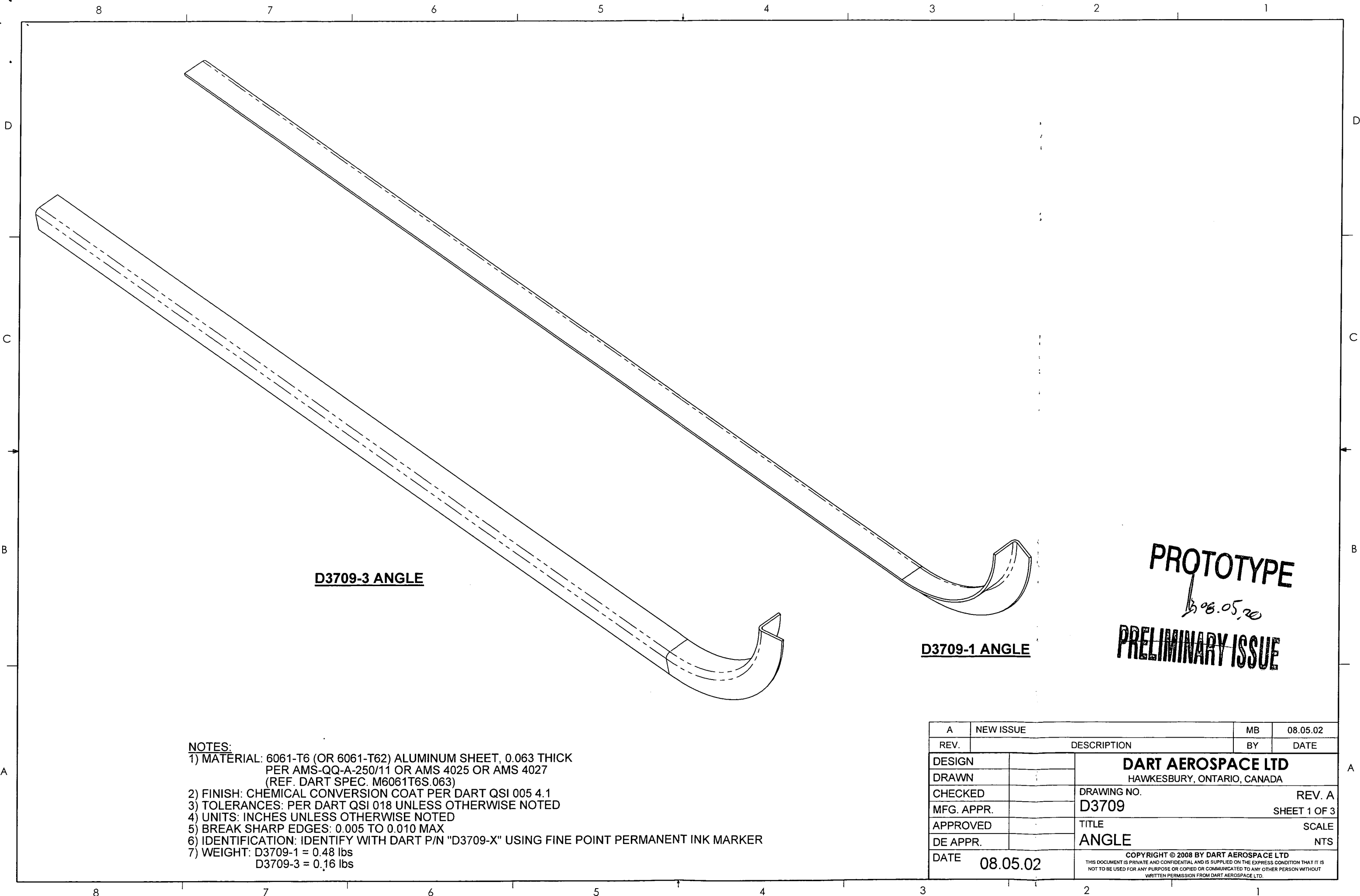
Comment: FINAL INSPECTION/W/O RELEASE

*08.05.21 PROTOTYPE*

Job Completion



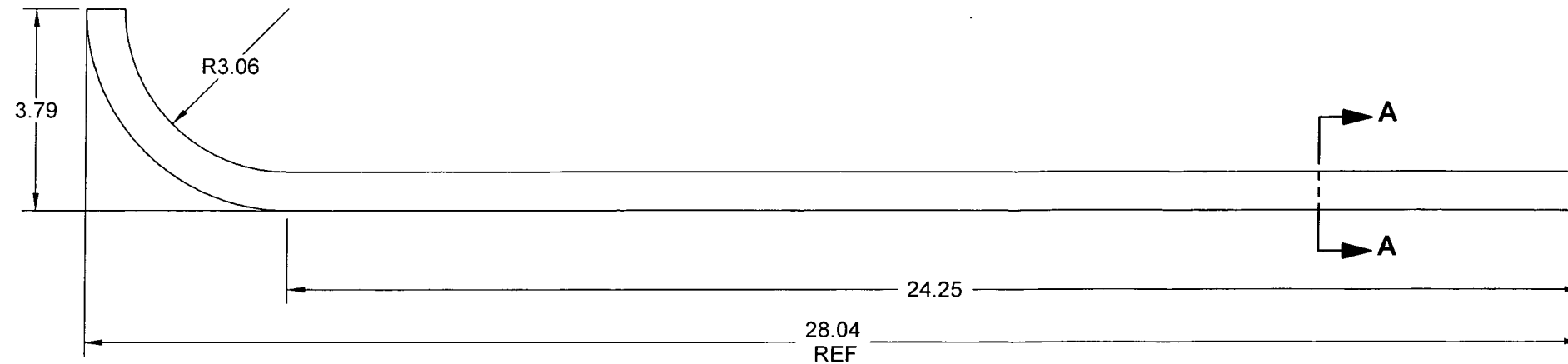
*mf 08-0612*



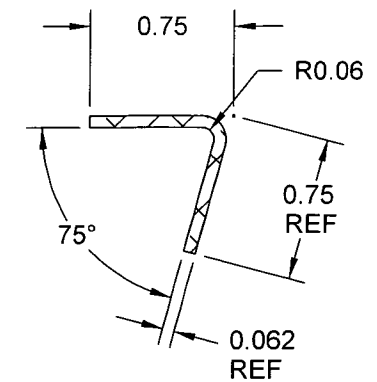
- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3709-X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3709-1 = 0.48 lbs  
D3709-3 = 0.16 lbs

**PROTOTYPE**  
08.05.02  
**PRELIMINARY ISSUE**

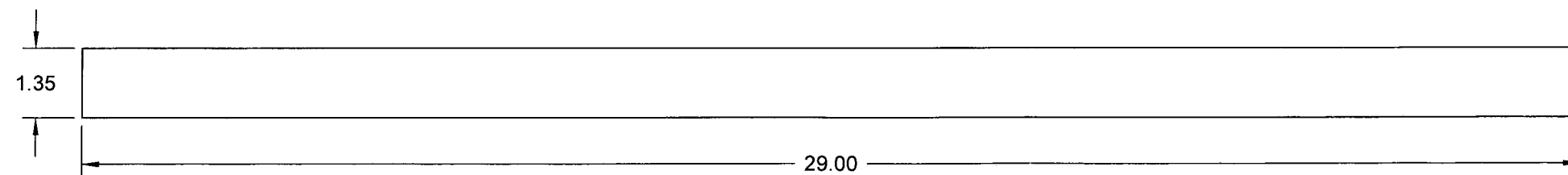
A	NEW ISSUE		MB	08.05.02
REV.	DESCRIPTION		BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.		REV. A
MFG. APPR.		D3709		SHEET 1 OF 3
APPROVED		TITLE		SCALE
DE APPR.		ANGLE		NTS
DATE	08.05.02		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**D3709-1 ANGLE**  
(MAKE FROM D3709-1F)



**SECTION A-A**  
SCALE 2X



**D3709-1F ANGLE FLAT PATTERN**

**PROTOTYPE**

**PRELIMINARY ISSUE**

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
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MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE <b>ANGLE</b>	SCALE
DE APPR.			NTS
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525 MELOCHE AVE.  
DORVAL, QUEBEC H9P 2W2  
(514) 631-1211 FAX: (514) 631-

VENDU À /  
SOLD TO:

LIVRÉ À /  
SHIP TO:

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY  
ONTARIO

K6A 1K7

COMMANDE SALES ORDER		CODE DE CLIENT CUSTOMER CODE		BON D'ACHAT DU CUSTOMER PURCHASE	
0165970		DART		5851	
LIVRÉ VIA - SHIP VIA		CONDITIONS - TERMS		DATE COMMANDE DATE ORDER	
NIR:R-557065-1		NET 30		Mar-	
CONTRÔLE DE QUALITÉ DU CLIENT REQUIS CUSTOMER QUALITY RELEASE REQ'D					
QUALITÉ QUALITY		UNITÉ UNIT	N° DE COULÉE HEAT NUMBER	DESCRIPTION	
COMMANDE ORDERED	A VENDRE - B/O				
4pc 8		lbs	F3153CR	304L ROUND 1/4" DIA	
2pc 26		lbs	41043	6061-T6 ALUM 3/4 SQ USE MTR #CA533	
3p 131		lbs	1628331	6061-T6 .063 X 48 X USE MTR #BZ853	
5pc 443		lbs	412603	6061-T6 AL FLAT 1 1 USE MTR #CE459	
TOTAL :					

NOMBRE DE PAQ. / NUMBER OF BOL'S: 1  
 Page: 1  
 08:50:24 20080311  
 MTR-AVEC COMMANDE / MTR'S-WITH ORDER: ☒  
 POSTE MAIL: ☐ TÉLÉCOPIEUR FAX: ☐  
 N° DE COULÉE ÉTAMPER SUR LE CÔTÉ / HEAT NO. STAMP ONE END: ☐

MATÉRIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Production/Admin: 08/03/18  
 Date: 18/13/18  
 Received/Costing: 18/13/18  
 Initial: CR

Location

Initials of receiver (if shipment OK) Level 12

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M20045040		128	0	0	128	
M6061T63150X015		20	0	0	20	

Discrepancies

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☒ No ☐  
 Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☒ No ☐  
 Waybill Attached: Yes ☒ No ☐  
 Shipment Complete: Yes ☒ No ☐  
 QC6 Inspection: ☐  
 Work Order: ☐

Date: 8/3/12  
 Supplier: MACVA  
 Batch No: 111.7357  
 Part P/O: 5851

Receiving report

BZ 853

DOC : V/0080236963

DATE : 2007-05-30

PROD. REF. : 0000217536/004

NRBST : 03484/04

PAGE : 1/ 2

## INSPECTION CERTIFICATE

# Aleris

## Europe

CUSTOMER : ALERIS ALUMINUM US SALES INC.

Aleris Aluminum Duffel BVBA  
A. Stoclaan 87, 2570 Duffel - Belgium

YOUR ORDER NUMBER : P08858 (CHARLESTON PO#5001-E)  
OUR ORDER NUMBER : 03484/04  
DOCUMENT NUMBER : V/0080236963

DESCRIPTION : ALU SHEETS (STENC) AA 6061-T6 AMS-QQA 250/11 AMS 4027M ASTM B209-04  
DIMENSIONS : 144" X 48" X .063"  
ARTICLE NO.:

0863/12

COIL  
NUMBER

CAST  
NUMBER

## CHEMICAL COMPOSITION (%)

	MIN	SI	FE	CU	MN	MG	CR	TI	ZN
	MAX	0,40		0,15		0,8	0,04		
		0,8	0,7	0,40	0,15	1,2	0,35	0,15	0,25
004	1628301	0,62	0,4	0,19	0,07	1,0	0,15	0,03	0,05
005	1628331	0,68	0,4	0,20	0,08	1,0	0,17	0,02	0,03

OTHERS : EACH  
TOTAL :

MIN  
MIN

0,05 MAX  
0,15 MAX

## MECHANICAL PROPERTIES

TEST-  
NUMBER

(T) = TRANSVERSAL

(L) = LONGITUDINAL

1 N/MM2 = 1 MPA = 0,1 HBAR

0,102 KG/MM2 = 0,145 KSI

/A = REAR END

/M = MIDDLE

/V = FRONT END

/O = RANDOM SAMPLING

	MIN	RM	RP02	A
	MAX	KSI	KSI	%
		42	35	10
004	/A	50	42	13
004	/M	49	42	16
004	/V	50	41	13
005	/A	50	41	16
005	/M	50	41	13
005	/V	50	41	18

Aleris Aluminum Duffel BVBA

59993  
24/12



Aleris Aluminum Duffel BVBA  
A. Stockmann 87, 2570 Duffel - Belgium

DATE SOLUTION HEAT TREATMENT COIL NUMBER  
004 STENCILLING : WEEK 17 / YEAR 2007  
005 STENCILLING : WEEK 17 / YEAR 2007

HEAD OF LABORATORY,  
XAVIER SCHELTJENS

A handwritten signature in dark ink, appearing to read "X. Scheltjens", written over a horizontal line.

Aleris Aluminum Duffel BVBA